⊾•Date: User: Friday, 02/05/2008 2:56:45 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 39022

Estimate Number P.O. Number

: 13154

This Issue

: 02/05/2008

: NC

: 37189

: //

Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D36621

Drawing Number

: D3662 REV A

Project Number Drawing Revision

: N/A : A

Material

Due Date

: 09/05/2008

: CROSSBOLT SPACER

Qty:

20 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est A 08.02.04

Now turned on Cobra EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Tube .625 x.049W

M6061T6T0625W049 1.0

Comment: Qty.:

6.5100 f(s)

6061-T6 Tube .6250 x.049W

0.3255 f(s)/Unit Total:

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

Batch M 106015

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA720

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0 QC8



Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #*

SECOND CHECK



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

121

Dart Ae	rospace Ltd							
W/O:		V	ORK ORDER CHANGES					
DATE	STEP PROCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		-						
Part No	:	PAR #: Fault Car	tegory: NC	CR: Yes	No DQ	A:	Date:	
		,		QA:	N/C Close	d:	_ Date: _	
NCR:		WORK ORI	DER NON-CONFORMANC	E (NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC	Corrective Action Section B			Verification					
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
				•							
		•									

NOTE: Date & initial all entries

Date:

Friday, 02/05/2008 2:56:46 PM

User: `

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 39022

Part Number: D36621

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

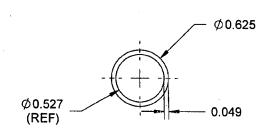
Job Completion

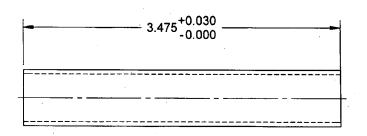


Dart Aerospace Ltd

DuitAu	. Copace E	tu .							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE By			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u>.</u>	PAR #:	Fault Cated	lory.	NCR: Yes	No DO	Δ.	Date:	
. ait 140.		1 70 %.	radit vates	Joily.				Date: _ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCI	₹)			
DATE		Description of NC	ION OT NC		ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Sect.	ion C	Chief Eng	QC Inspecto
					-				
			1			1		1	

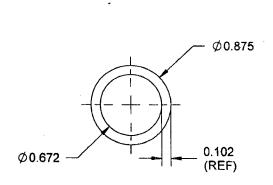
NOTE: Date & initial all entries

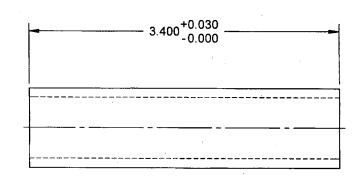




ENGINEERING UNCONTROLLED

D3662-1 CROSS BOLT SPACER





D3662-3 CROSS BOLT SPACER

NOTES: 1) MATERIAL:

D3662-1 -**ALUMINUM 6061-T6/T62**

TUBING PER WW-T-700/6 OR AMS 4080/4082

OR QQ-A-200/8 OR QQ-A-225/8

(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49) ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)

D3662-3 -

ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 M AX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3662-1 0.03 LBS

D3662-3 - 0.08 LBS

			· · · · · · · · · · · · · · · · · · ·				
Α	NEW ISS	NEW ISSUE PH					
REV.		C	BY	DATE			
DESIG	N	P#	DART AEROSPACE U	JSA	. INC.		
DRAWN PA			PORT HADLOCK, WA				
CHECK	(ED	لف	DRAWING NO.		REV. A		
MFG. A	MFG. APPR.		D3662		SHEET 1 OF 1		
APPRO	OVED	M	TITLE		SCALE		
DE API	PR.	4	CROSS BOLT SPACER	į.	1:1		
DATE	07.0	4.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT MODIFIED RESIDENCE FOR ANY FOR THE PERSON WITHOUT MODIFIED RESIDENCE FOR ANY ADMINISTRATED TO ANY OTHER PERSON WITHOUT				

DART AEROSPACE LTD	Work Order: 39022
Description: Cross (6) Shacer	Part Number: 53662
Inspection Dwg: Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.625	\$00.00	.625	4			
Ø.625 Ø.527(R)	+0.00B	.531	V			AND MARKET TO THE PARTY OF THE
.049	+ 0,0/0 +0.030	.046	J			
3.475	0.030 000.0 =	3,487	$\sqrt{}$			
-						sampagan sabas dan
Common and			:			. : .
and the state of t						
Prosition						•
7						
						·
						and the second
r _{atio}						, or or or one
						errore.
5 * #						

Measured by: MM / DT?	Audited by:	Prototype Approval:	NIA
Date: 08/05/06	Date: 08/05/26	Date:	

Rev	Date	Change	Revised	by	Approved
Α		New Issue	KJ/JLM	j	
	·				

